



PATENT ABSTRACTS OF JAPAN

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F02F 1/24(21)Application number: **02240477**(22)Date of filing: **11.09.90**(71)Applicant: **TOYOTA MOTOR CORP**(72)Inventor: **KAWASAKI MINORU**
TAKAGI MUNEYA
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KATO SHINJI**(54)CLADDING METHOD BY WELDING FOR
VALVE SEAT PARTS OF CYLINDER HEAD****(57)Abstract:**

PURPOSE: To efficiently clad by welding on the valve seat parts of the cylinder head by fitting a jig to roughly formed material close to the valve seats, filling up metal powder for cladding by welding in recessed grooves and irradiating the metal powder with high density energy to form cladding layers.

CONSTITUTION: The jig 26 is fitted to cylinder head roughly formed material 10 close to the valve seat parts 42 and 44 and the annular recessed grooves 28 and 30 having the double depths d_1 and d_2 at least of the thickness of the cladding layers 38 and 40 to be formed on the valve seat parts 42 and 44 are formed hereby. Accordingly, the cladding layers 38 and 40 having the sufficient thickness can be formed even in the parts where the valve seat parts 42 and 44 are

adjacent to each other and the occurrence of underfill parts of the cladding layers can be surely avoided hereby.

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